Claims:

1. (Currently amended) Method for the manufacture of a ball valve (1) between two tubes (3,4), in which method the ends (7, 8) of ~~the~~ said tubes are sealed against rotatable valve balls (2) opening and closing ~~the~~ said valve, and ~~the~~ said valve ball and ~~the~~ said tube ends are surrounded by a sleeve-like cover (10) to be jointed to ~~the~~ mantle surfaces of ~~the~~ said tubes, characterized in that ~~the~~ said mantle of ~~the~~ said tube (3, 4) has a front face (29) formed by a beveling or stepping, narrowing it towards ~~the~~ said ends (7, 8) of ~~the~~ said tube, that ~~the~~ said sleeve-like cover (10) has an end face (22, 23) directed similarly to ~~the~~ said front face of ~~the~~ said tube, that ~~the~~ said front face of ~~the~~ said tube and ~~the~~ end face of ~~the~~ said cover are brought against each other, and that ~~the~~ said tube and said cover are jointed to each other by beam welding by directing ~~the~~ a welding beam (31) between said faces brought against each other, following their direction.

2. (Currently amended) Method according to Claim 1, characterized in that ~~the~~ said mantle of ~~the~~ said tube (3, 4) has turns (27, 28) on both sides of ~~the~~ said front face (29) so that ~~the~~ said welding beam penetrating ~~the~~ a joint (11, 12) formed by the opposite surfaces hits the turn and the material of ~~the~~ said tube mantle below.

3. (Currently amended) Method according to Claim 1 or 2, characterized in that ~~the~~ said beveled front face (29) of ~~the~~ said mantle of ~~the~~ said tube (3, 4) is in an angle of approximately 30-60°, preferably approximately 45° in relation to the axial direction of ~~the~~ said tube.

4. (Currently amended) Method according to ~~one of the preceding claims,~~ Claim 1 or 2 characterized in that it is used for the manufacture of a said ball valve with a reduced aperture (5, 6).

5. (Currently amended) Method according to ~~one of the claims 1-3,~~ Claim 1 or 2 characterized in that it is used for the manufacture of a said ball valve with a full aperture so that

~~the~~ said mantle of ~~the~~ said tube (3, 4) has been expanded (32) and then narrowed for achieving ~~the~~ said beveled front face (29) for jointing ~~the~~ said sleeve-like cover (10).

6. (Currently amended) Method according to ~~one of the preceding claims,~~ Claim 5 characterized in that ~~the~~ said cover (10) is attached to ~~the~~ said mantle of ~~the~~ said tube (3, 4) by laser welding (30, 31).

7. (Currently amended) Method according to ~~one of the claims 1-5,~~ Claim 5 characterized in that ~~the~~ said cover (10) is attached to ~~the~~ said mantle of ~~the~~ said tube (3, 4) by electron beam welding.

8. (Currently amended) Method according to ~~one of the preceding claims,~~ Claims 1 or 2 characterized in that an aperture (20) is provided to ~~the~~ said cover (10), to which aperture ~~the~~ a spindle (13) rotating ~~the~~ said valve ball (2) and ~~the~~ a surrounding support sleeve (14) are fitted, ~~the vale ball (2) and the said surrounding support sleeve (14) are fitted,~~ the said support sleeve being jointed to ~~the~~ an edge (21) of ~~the~~ said aperture by beam welding.

9. (Currently amended) Method according to Claim 8, characterized in that ~~the~~ said cover (10) is shaped so that ~~the~~ an edge (21) of ~~the~~ said aperture (20) is located in one plane parallel to the axis of ~~the~~ said tubes (3, 4).

10. (Currently amended) Method according to Claim 9, characterized in that ~~the~~ mating faces (21, 26) of ~~the~~ said edge (21) of ~~the~~ said aperture (20) and ~~the~~ said support sleeve (14) of ~~the~~ said spindle, which are jointed together by beam welding, are in an angle of 30-60°, preferably approximately 45° in relation to the axial direction of ~~the~~ said tubes (3, 4).

11. (Currently amended) The use of beam welding, such as laser or electron beam welding in the assembly of a ball valve (1) when attaching ~~the~~ a sleeve-like cover (10) surrounding ~~the~~ a valve ball (2) and ~~the~~ said ends (7, 8) of ~~the~~ said tubes (3, 4) sealed against it

from ~~its~~ said ends (22, 23) to ~~the~~ said flanks of the tubes.

12. (Currently amended) The use of beam welding, such as laser or electron beam welding in the assembly of a ball valve when attaching ~~the~~ a support sleeve (14) of ~~the~~ a spindle rotating ~~the~~ a valve ball (2) to ~~the~~ an aperture (20) made to ~~the~~ a sleeve-like cover (10) surrounding ~~the~~ said valve ball ~~and the~~ having ends (7, 8) of ~~the~~ said tubes (3, 4) sealed against it.